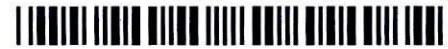




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2332-041
Job Sheet 163046



Part No: D2332-041

Job Qty: 4 ea

Part Name: Lid Prop Assembly 6.69"



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 11/15/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Helicocean Aerosystemes (CHOCE01)

130, Rue R, Gervolino, Bp 16694, Cedex Noumea, , 98804 New Caledonia ph:687 25 39 49

Note: DWG REV C1 IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF IPP Rev:C 08-06-02 add comment DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/14/17	0.00	0.00	Start Up Large Fab-1		FF
100	Small Fab	4 pcs		11/14/17	0.32	1.27	Small Fab		FF
110	Brake NC	4 pcs		11/14/17	0.00	0.46	Brake NC 3		FF
120	Small Fab	4 pcs		11/14/17	0.00	1.27	Small Fab		DAS FF
130	QC	4 pcs		11/14/17	0.00	0.00	QC5		38
140	Large Fab	4 pcs		11/14/17	0.00	1.00	Large Fab 1		9-89 JSC
150	QC	4 pcs		11/14/17	0.00	0.00	QC9		PD 18-3-23
160	QC	4 pcs		11/14/17	0.00	0.00	QC5		PD 13-3-23
170	Small Fab	4 pcs		11/15/17	0.00	1.27	Small Fab		FF DAS
180	QC	4 pcs		11/15/17	0.00	0.00	QC5		38
190	Packaging	4 pcs		11/15/17	0.00	0.00	Packaging3	ST 367	21 MAR 28 2018
200	QC21-SA	4 Ea		11/15/17	0.00	0.00	QC21		21 MAR 28 2018

Part Op 100 - 1- Cut D2332-7 and D2332-5 to length as per dwg D2332. 2- Cut D2332-11 using 1/2" S.S tubing 7.735" long. 3- Descriptions: Deburr.

110 - Punch and form D2332-11 to length as per dwg D2332 using DT8012 (need 2 per ass'y)

120 - 1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y) 2- Ensure no foreign objects inside tube

140 - Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y) *****ensure nothing is inside of tube before welding***** S.S Rod batch: _____

170 - 1- Tumble 2- Assemble as per dwg D2332

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304R.250	0	15	0 M 135249	0
	M304TR1.000W.049	2	16	0 m 125250	0
110-Brake NC	M304TR0.500W.035	5	99	0.5034342	0
170-Small Fab	346 AN4-4A	4	56	0 5044215	0
	303 MS21042L4	4	4,124	0 5045901	0
	264 NAS1149D0416J	12	3,442	0 Fm 131511	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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Description Work Order Deviation

--

Root Cause			FAULT CATEGORY		
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
☐ Past Expiry Date	☐ Manufacturing Process	OTHER : _____			
☐ Misidentified	☐ Past Due				

Work Order update only

Part: D2332 - 041
 Job No: 163046
 Serial No/Batch: S053288
 Revision:
 Inspector:



DART
AEROSPACE

Unit Aerospace Ltd.
 1270 Abchurch Lane
 Hamilton, ON K8A 1K7
 Canada
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaero.com

Date: 03/21/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lid Prop Assembly	5.000Inches $\pm$ 0.030	5.030 4.970		
2	Lid Prop Assembly	1.250Inches $\pm$ 0.010	1.260 1.240		
3	Lid Prop Assembly	6.690Inches $\pm$ 0.010	6.700 6.680		

Plex 12/19/17 10:53 AM dart.lacelle.linda

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							